

NCR Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: John Date: 13/03/11QA Closed: CC Date: 13/3/11

Work Order: <u>96828</u>	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. <u>D3876-7</u>	Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input checked="" type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
NCR No. <u>13-3365</u>									

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	12-2-22	100	2x	PART MOVED CAUSED UNEVEN SURFACE ON TOP. USE MORE WEIGHTS. OPERATOR ERROR.	DAS 16 9-89 Q31042 13/2/22	SCRAP + Destroy Recut w/ B# <u>124654</u> Qty x2	JM	DAS 15 9-89	DAS 16 9-89 Q31042 13/2/22
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear				General			
Bending	Bend	Grain	Ovalized	Pressure/Forced			
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure			
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld			
Crushed/Crimped	Burrs	Instructions Incomplete	Part Lost/Missing	Wrong Stock Pulled			
Cuffs	Contamination	Maintenance	X Part Moved				
Heat Treat	Countersink	Mislabeled	Positioned Wrong				
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge				
Ripples in Bend	Drill Holes	Offset	Other				
Torque Waves in Extrusion	Drawing	Out of Calibration					
Turning Sequence	Finish	Out of Sequence					
Wave/Twist in Tube	Folio	Outside Dimensions					

Work Order ID 96828

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96828

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Item ID: D3876-7

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Protector - Aft Wall

Stop

NS2Start Date: 2/07/13 Start Qty: 12.00 ***12***

Cust Item ID:

Required Date: 3/22/13 Req'd Qty: 12.00 ***12***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

13/2/26 (12)

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

13/2/26 (12)

MF

13-2-26

NCR: Yes / No

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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
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Unapproved											
FAULT CATEGORY											
Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				General Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/>		Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/>				Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other <input type="checkbox"/>	

Picklist Print

February-07-13 8:22:36 AM

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Work Order ID: 96828

96828
D3876-7

Parent Item: D3876-7

Parent Item Name: Protector - Aft Wall

Start Date: 2/07/13

Required Date: 3/22/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 09-01-14 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	11.6273	2.49	31.45263	**	40	JM13-2-21

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

Location	Loc Qty	Loc Code
MAT019	11.6273	
121803	11.6273	

124654

124654

NCR: Yes / No

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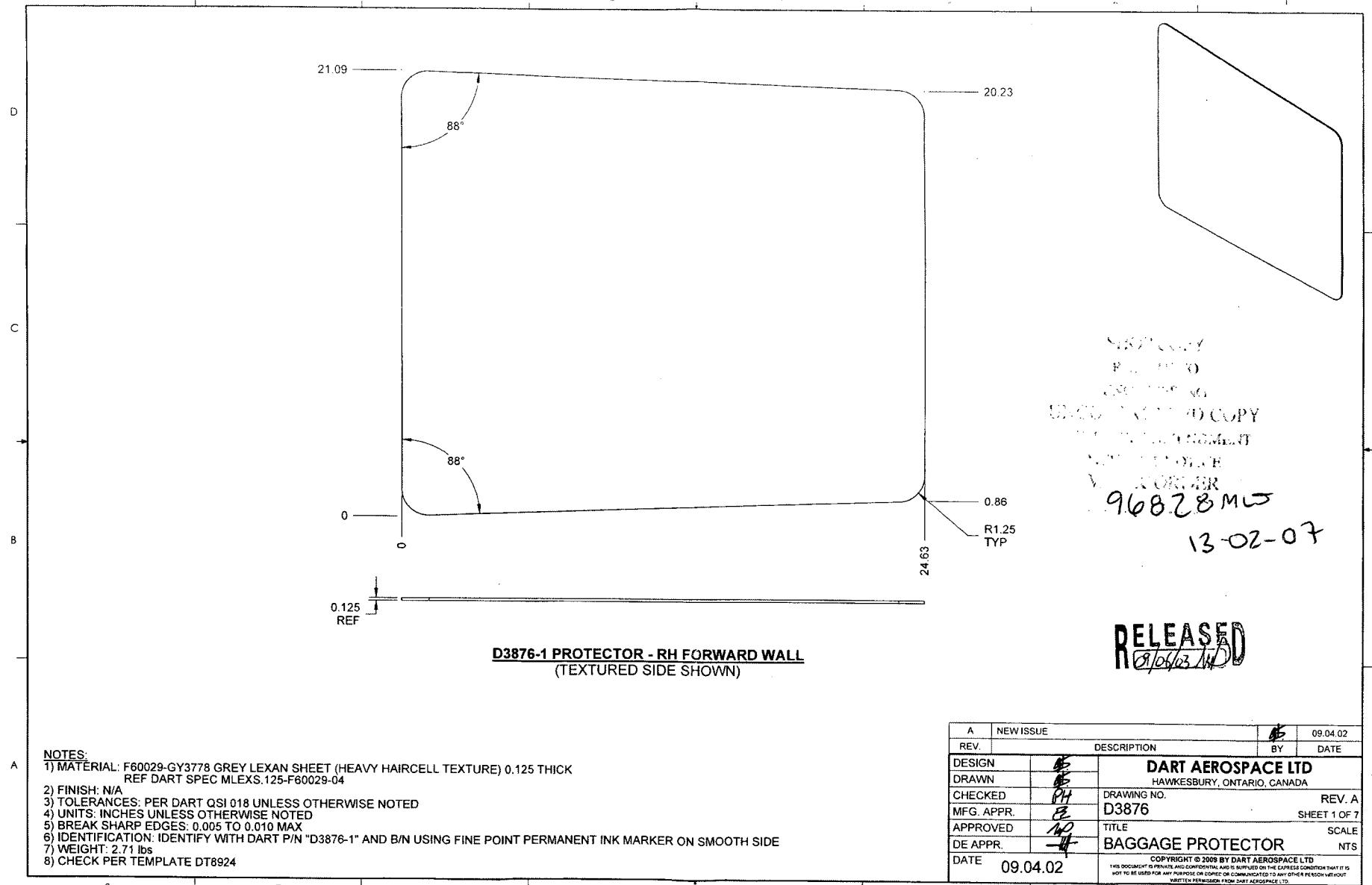
DART AEROSPACE LTD	Work Order:	96828
Description: Protector – Aft Wall	Part Number:	D3876-7
Inspection Dwg: D3876	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

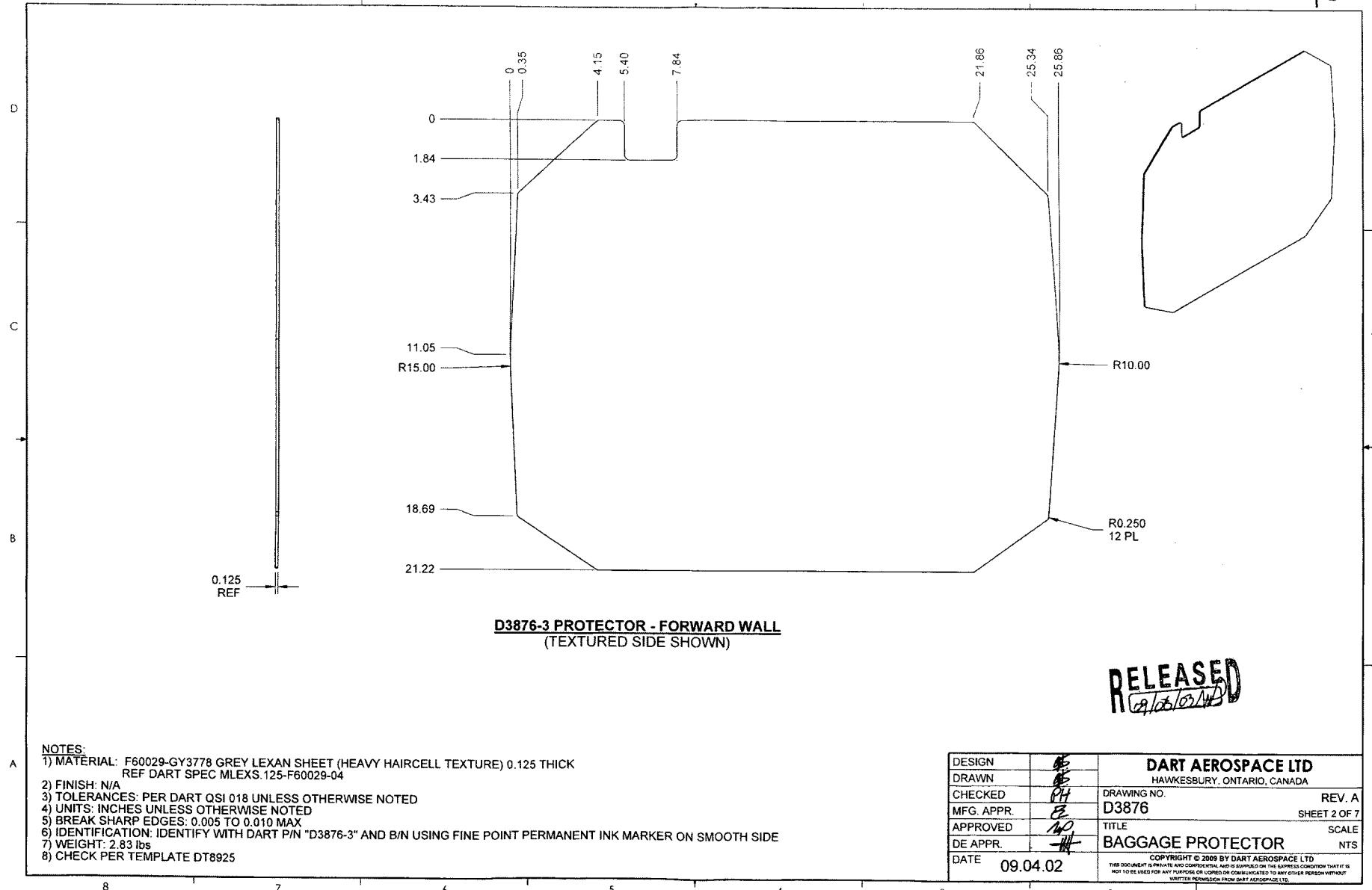
X First Article Prototype

Measured by:	Jm	Audited by:	15	Prototype Approval:	N/A
Date:	13-2-21	Date:	13.2.20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.22	New Issue	KJ	

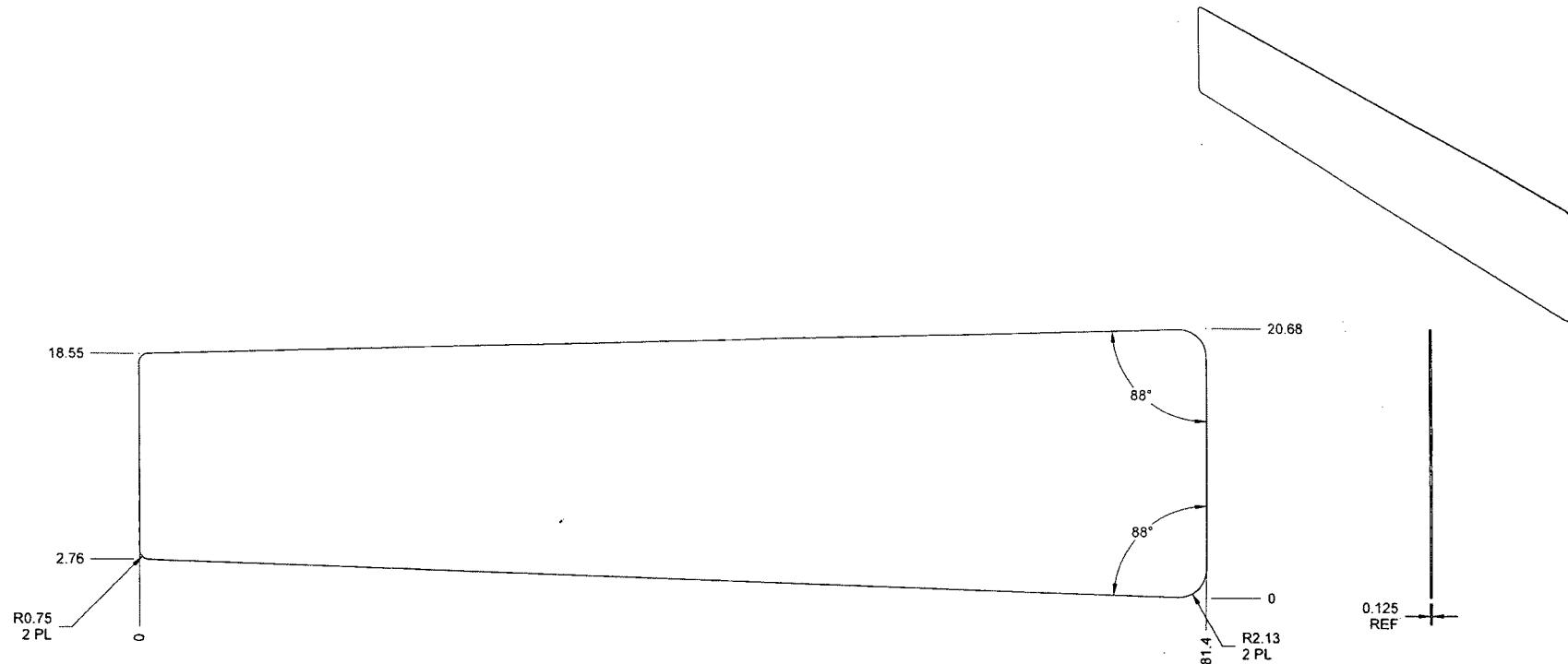


96878



DESIGN	<i>AB</i>	DART AEROSPACE LTD	
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	
MFG. APPR.	<i>EZ</i>	REV. A	
APPROVED	<i>AB</i>	SHEET 2 OF 7	
DE APPR.	<i>AB</i>	TITLE	
DATE	09.04.02	SCALE	
		NTS	
		BAGGAGE PROTECTOR	
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96828



D3876-5 PROTECTOR - LH WALL
(TEXTURED SIDE SHOWN)

RELEASED
07/06/03 AM

NOTES:

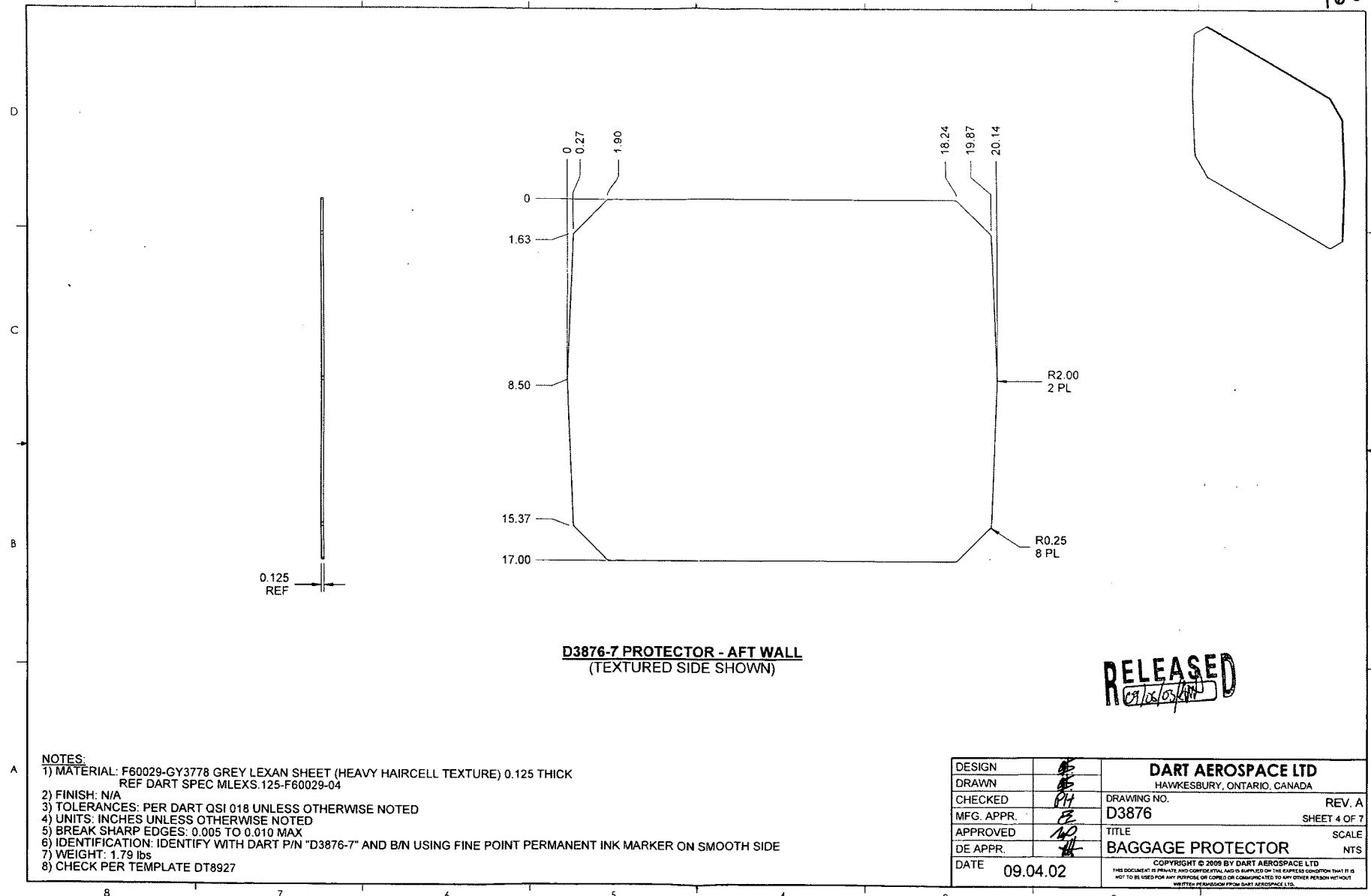
- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3876-5" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
- 7) WEIGHT: 8.07 lbs
- 8) CHECK PER TEMPLATE DT8926

8 7 6 5 4 3 2 1

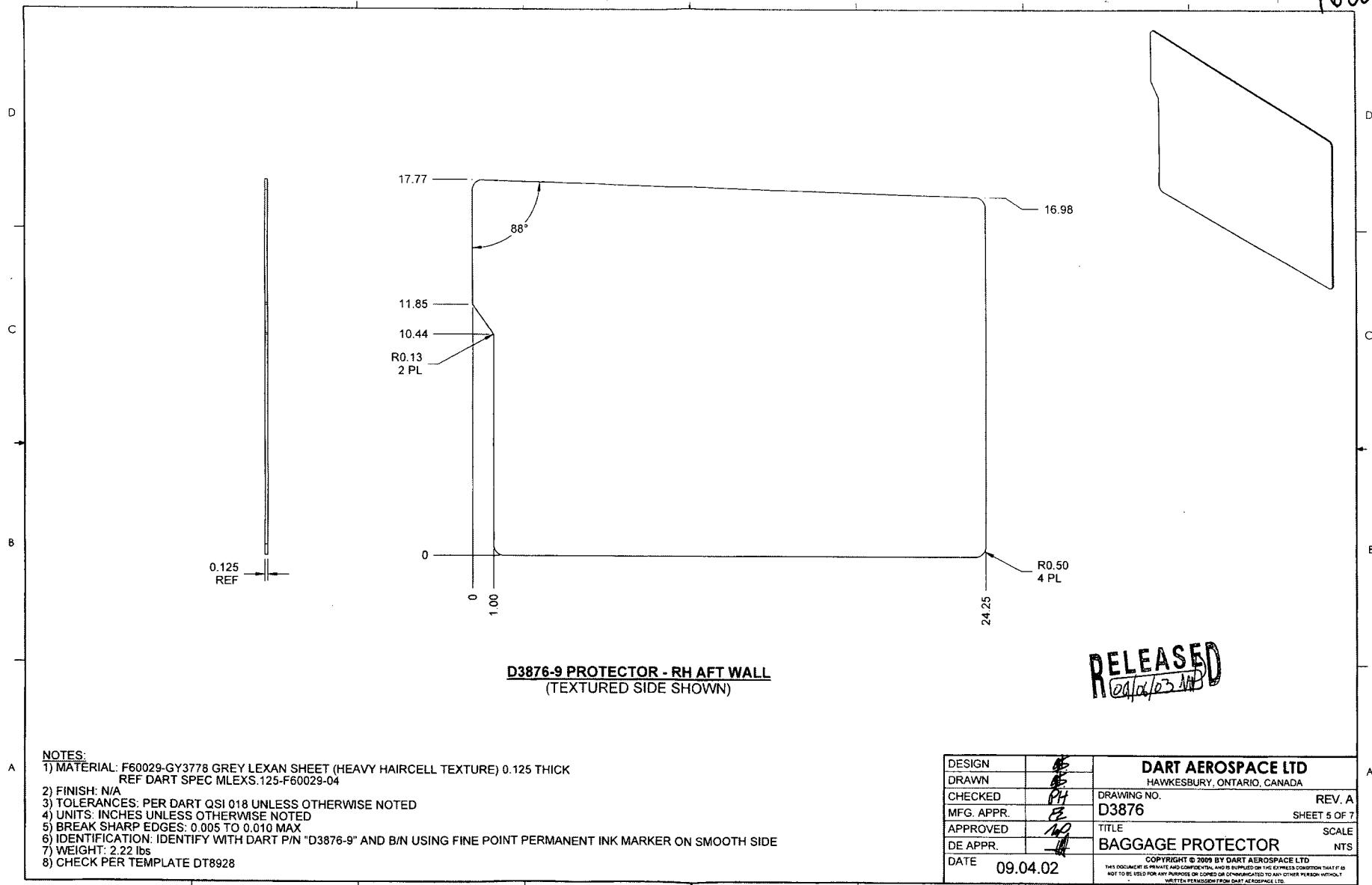
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DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AB</i>	D3876	SHEET 3 OF 7
APPROVED	<i>AB</i>	TITLE	SCALE
DE APPR.	<i>AB</i>	BAGGAGE PROTECTOR	
DATE	09.04.02	NTS	

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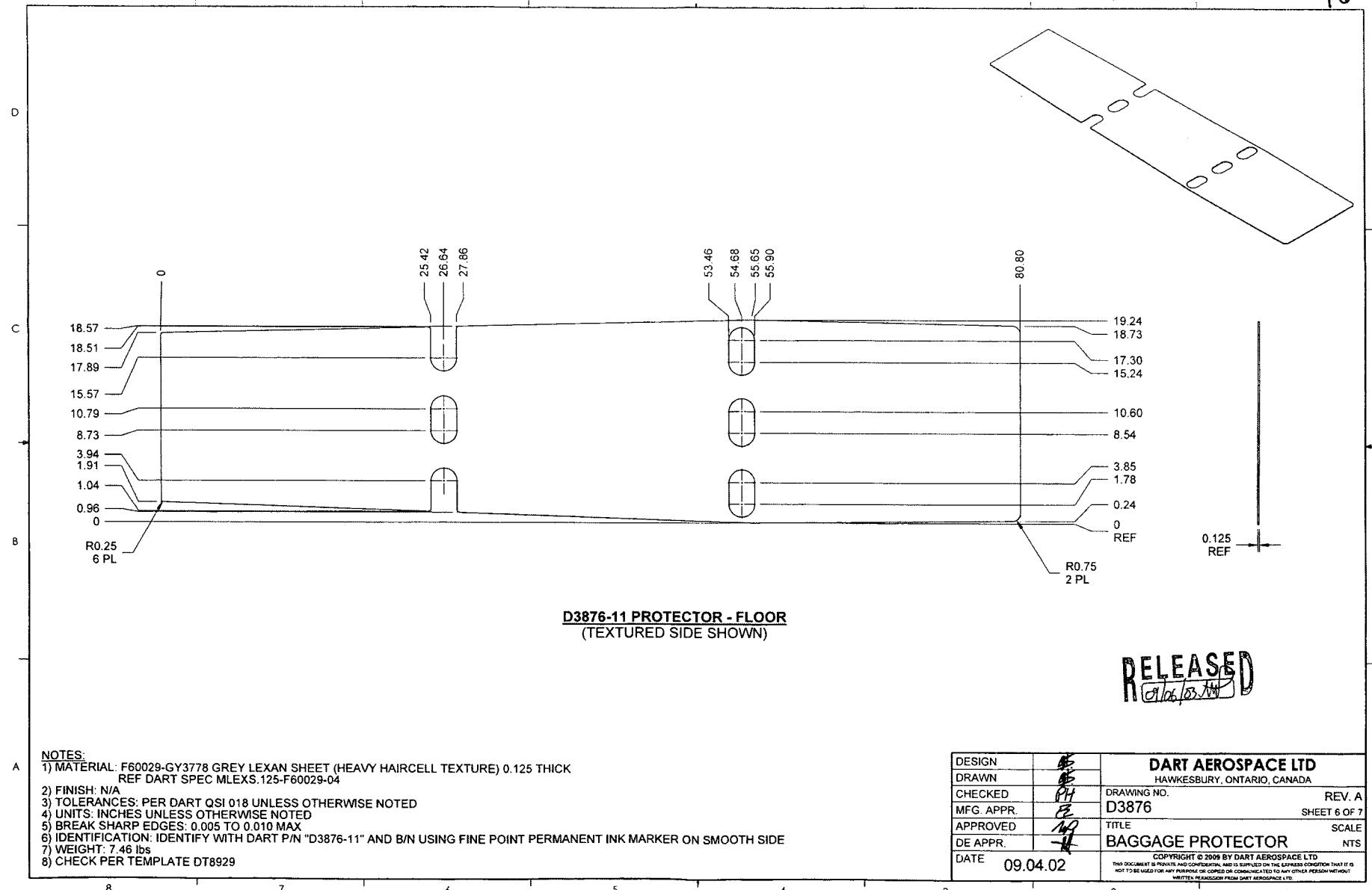
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